

Work Order ID 127661

127661

Page 1

December-17-14 1:42:37 PM

Item ID: D3929-041 Accept ***N9000040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Gusset Assembly
 Start Date: 12/12/14 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 12/17/14 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: 12-23 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3929	Rev A								
110	QC8- Inspect parts - second check	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	Weld per dwg A/R S.S. rod Batch: _____	0.00							
120									
Large Fab	Memo	0.00							
Large Fab	Weld bushings D3907-1 as per dwg D3929								
130	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
130									
QC	Memo	0.00							
Quality Control									

Scrap

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

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Item ID: D3929-041 **Accept** ***N9000040100*** **Setup Start** ***NS1***
Revision ID: **Stop** ***NS2***
Item Name: Gusset Assembly
Start Date: 12/12/14 **Start Qty:** 8.00 ***8*** **Cust Item ID:**
Required Date: 12/17/14 **Req'd Qty:** 8.00 ***8*** **Customer:**
Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** ***NR1***
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00							
Quality Control									
150	Identify as per dwg & Stock Location: _____	0.00							
150									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

15-3-12

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Work Order ID: 127661

127661

Parent Item: D3929-041

D3929-041

Parent Item Name: Gusset Assembly

Start Date: 12/12/14

Required Date: 12/17/14

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A 13.09.06 AS PER REV.A DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3929-1 *D3929-1* Support Gusset		Manufactured	No			110	Each	0.0000	1	8			
									**				
D3907-1 *D3907-1* Bushing		Manufactured	No			110	Each	49.0000	2	16			
									**				

Location

Loc Qty

Loc Code

WA002

49

112653

9

112659

40

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

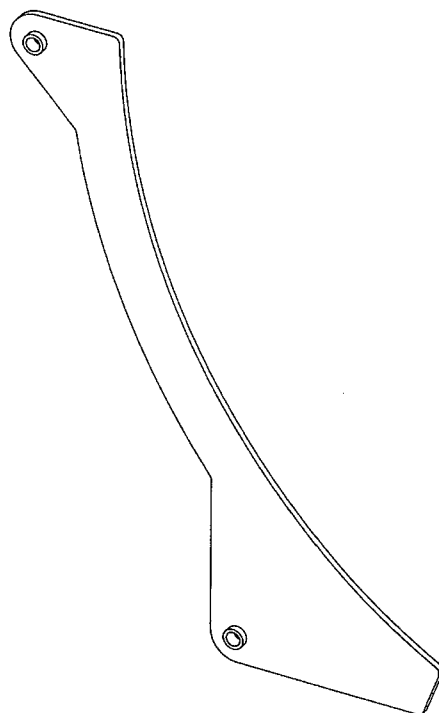
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Training									
Transport									
Unapproved									

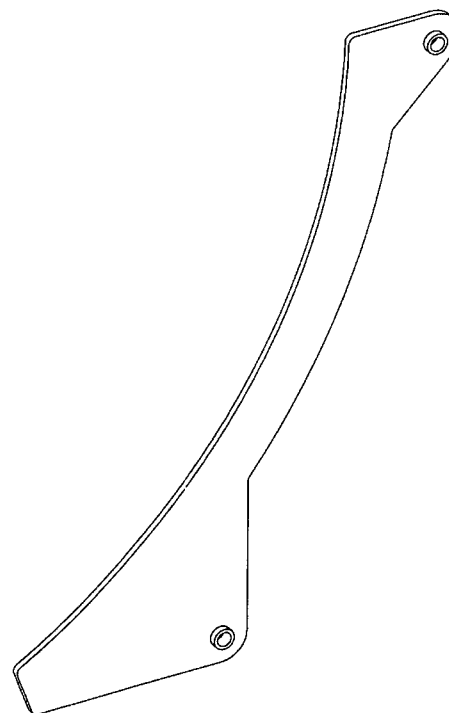
FAULT CATEGORY

Landing Gear	General		
☐ Bending	☐ Bend	☐ Folio/Program	☐ Outside Dimensions
☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance
☐ Cracks	☐ Broken/Damage/Defect	☐ Hardware	☐ Part Incorrect
☐ Crimp/Kink/Ripple/Wave	☐ Burrs	☐ Inspection Incomplete/Unqualified	☐ Part Lost/Missing
☐ Cuffs	☐ Contamination	☐ Instructions Incomplete/Unclear	☐ Part Moved
☐ Crushing	☐ Countersink	☐ Misaligned/off center	☐ Positioned Wrong
☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Power Loss/Surge
☐ Inspection Strip in Tube	☐ Drawing	☐ Misread	☐ Pressure/Forced
☐ Marks/Chatter	☐ Drill Holes	☐ Off-set	☐ Set-up
☐ Turning Sequence	☐ Finish	☐ Out of Calibration	☐ Temperature/Cure
☐ Wave/Twist in Tube	☐ Fit/Function	☐ Out of Sequence	☐ Weld
			☐ Wrong Stock Pulled
			☐ Other

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3929-041	GUSSET ASSEMBLY
2		X	D3929-042	GUSSET ASSEMBLY
11	2	2	D3907-1	BUSHING
12	1	1	D3929-1	SUPPORT GUSSET



D3929-041 GUSSET ASSEMBLY



D3929-042 GUSSET ASSEMBLY

UNCLASSIFIED
SUBJECT: [illegible]
NO. 127661 MJS
14-12-23

RELEASED
8/6/12 MD

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3929-04X" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.73 lbs EACH
 - 8) WELDING: PER DART QSI 004

A	NEW ISSUE	DESCRIPTION	MB	09.04.03
REV.			BY	DATE
DESIGN				
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	09.04.03			

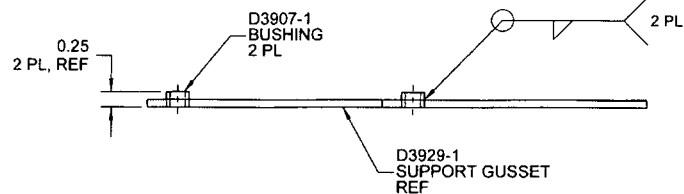
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3929** REV. A
SHEET 1 OF 3
TITLE **GUSSET ASSEMBLY** SCALE NTS

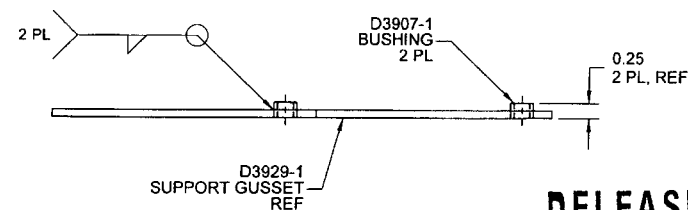
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D3929-1
SUPPORT GUSSET
2 PL

D3929-1
SUPPORT GUSSET
2 PL



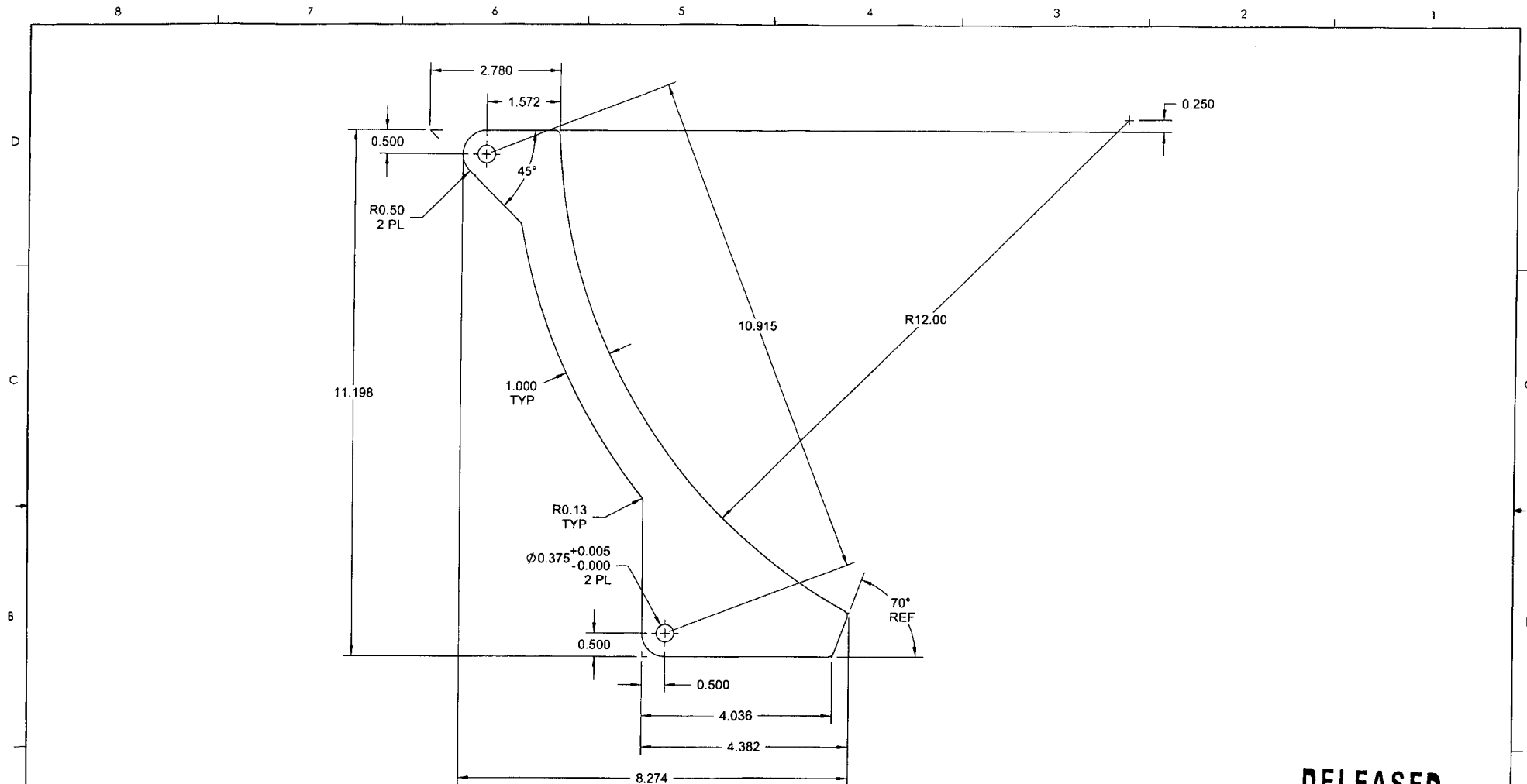
D3929-041 GUSSET ASSEMBLY



D3929-042 GUSSET ASSEMBLY

RELEASED
09/04/22

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3929	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		GUSSET ASSEMBLY	NTS
DATE	09.04.03	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



D3929-1 SUPPORT GUSSET

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
11 GAUGE (0.125 THICK)
REF. DART SPEC. M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.72 lbs

RELEASED
9/10/12-1ND

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3929	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		GUSSET ASSEMBLY	NTS
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